



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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647.1702

Job Sheet 210360



Part No: 647.1702

Job Qty: 1 pcs

Part Name: Skid Deflector Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/5/20

Job Tracking No:

Due Date: 9/1/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: 647.1700 REV.F IPP REV:A NEW ISSUE 13.07.17 JLM VERIFIED BY:DD IPP REV:B 14.09.26 AS PER DWG
C1 DD VERF:JLM IPP REV:C 20.07.07 AS PER DWG REV.F DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Small Fab - 1	1 pcs		8/31/20	0.00	1.50	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
							Small Fab - Various 1		
121	Conventional Mill - 1 - B4B	1 pcs		8/31/20	0.25	0.25	Conventional Mill - 1 - B4B		D. 20-07-13
122	QC 2	1 pcs		8/31/20	0.00	0.00	QC 2 - 1		D. 20-07-13
123	QC 8	1 pcs		8/31/20	0.00	0.00	QC 8 - 1 (A)		DJP 20-07-13
125	Handfinish - 6-1- Touch Up-B4B	1 pcs		9/1/20	0.00	0.17	Handfinish - 6 - 1 - B4B		DAS - 87 JUL 15 2020 9-89
130	QC 5	1 pcs		9/1/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
210	Packaging 3-1 - Stock - B4B	1 pcs	9/1/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
220	QC 21 - SA	1 pcs	9/1/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9

OKS

21

9-89

JUL 16 2020

Part Op 120 - 1- Assemble item 4,6,7 and 8 as per dwg. 2- Clamp item 1 and 2 to item 3. Transfer drill holes as per dwg see note
 Descriptions: 6. Use clecos. 3- Disassemble parts 4- Deburr 5- Touch up expose aluminum with alodine *** **TOUCH UP RIVET WITH
 PRIMER *** PRIMER BATCH: _____ *** 6- Re-assemble as per dwg
 121 - Machine out slots on detail AA (2pl) .400 x .150
 122 - QC2- Inspect parts off machine FAI/FAIB
 123 - QC8- Inspect parts - second check
 125 - Touch up alodine and primer Primer Batch: 5265778
 130 - (QC5- Inspect part completeness to step on W/O)
 210 - (Identify as per dwg & Stock Location: _____), ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND
 REV***
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
647.1712	Gusset	1 pcs (1 ea)	120-Small Fab - 1	
647.1713	Spacer	1 pcs (1 ea)	120-Small Fab - 1	
647.1714	Plate	1 pcs (1 ea)	120-Small Fab - 1	
647.1715	Plate	1 pcs (1 ea)	120-Small Fab - 1	
CR3213-4-4	Rivet, Cherry	22 Ea (22 ea)	120-Small Fab - 1	
MS21042L3	Nut	1 Ea (1 ea)	120-Small Fab - 1	
MS27039-1-14	Screw	1 Ea (1 ea)	120-Small Fab - 1	
NAS1149F0332P	Washer (AN960-10L)	2 Ea (2 ea)	120-Small Fab - 1	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Small Fab - 1	647.1712	1	28	0
	647.1713	1	33	0
	647.1714	1	0	0
	647.1715	1	0	0
	CR3213-4-4	22	538	0
	MS21042L3	1	1,021	0
	MS27039-1-14	1	417	0
	NAS1149F0332P	2	1,966	0

Part Specifications				
Specifications could not be found.				



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Split

647.1702

Job Sheet 210360



Part No: 647.1702

Job Qty: 10 pcs

Part Name: Skid Deflector Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/5/20

Job Tracking No:

Due Date: 9/1/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 13.07.17 JLM VERIFIED BY:DD IPP REV:B 14.09.26 AS PER DWG C1
DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Small Fab - 1	10 pcs	9/1/20	9/1/20	0.00	4.10	Small Fab - 1		DAS 58 JUN 29 2020 JUN 29 2020
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
							Small Fab - Various 1		
130	QC 5	10 pcs	9/1/20	9/1/20	0.00	0.00	QC 5 - 10		20-07-16 DAS 40 JUN 29 2020
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		



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CANADA
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Container No: S285275



Part: 647.1702

Job No: 210360

Serial No/Batch: S285275

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/29/20

210 Packaging 3-1 - Stock - B4B 10 pcs

9/1/20

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B ✓ CCK033

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

Packaging 3 - 37 - B4B

JUL 16 2020

DAS

80

9.89

220 QC 21 - SA

10 pcs

9/1/20

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 9

Part Op 120 - 1- Assemble item 4,6,7 and 8 as per dwg. 2- Clamp item 1 and 2 to item 3. Transfer drill holes as per dwg see note
 Descriptions: 6. Use clecos. 3- Disassemble parts 4- Deburr 5- Touch up expose aluminum with alodine *** **TOUCH UP RIVET WITH
 PRIMER *** PRIMER BATCH: _____ *** 6- Re-assemble as per dwg
 130 - (QC5- Inspect part completeness to step on W/O)
 210 - (Identify as per dwg & Stock Location: _____), ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND
 REV***
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.1712 CCK031	Gusset	10 pcs (1 ea)	120-Small Fab - 1	5078855
647.1713 CCK107	Spacer	10 pcs (1 ea)	120-Small Fab - 1	5046687
647.1714 CCK044	Plate	10 pcs (1 ea)	120-Small Fab - 1	5056674
647.1715	Plate	10 pcs (1 ea)	120-Small Fab - 1	5057421
CR3213-4-4	Rivet, Cherry	220 Ea (22 ea)	120-Small Fab - 1	5082132
MS21042L3	Nut	10 Ea (1 ea)	120-Small Fab - 1	5067766
MS27039-1-14	Screw	10 Ea (1 ea)	120-Small Fab - 1	5162000
NAS1149F0332P	Washer (AN960-10L)	20 Ea (2 ea)	120-Small Fab - 1	5047891

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Small Fab - 1	647.1712	10	42	0
	647.1713	10	47	0
	647.1714	10	41	0
	647.1715	10	31	0
	CR3213-4-4	220	642	0
	MS21042L3	10	1,055	0
	MS27039-1-14	10	151	0
	NAS1149F0332P	20	1,925	0
Part Specifications				
Specifications could not be found.				

Plex 6/5/20 12:49 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

